

Date: Tuesday, 14/04/2009 11:04:20 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GUIDE
 Job Number : 47142
 Estimate Number : 12807
 P.O. Number : Part Number : D35713
 This Issue : 14/04/2009 S.O. No. : Drawing Number : D3571 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 40531 Material :
 Written By : MF 09-04-14 Due Date : 21/04/2009 Qty: 20 Um: Each
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-02-01 JLM
 Est Rev:B Remove manual Machinig 08-05-26 JLM Verified
 By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X01500 6061-T6 Bar .750 X 1.50



Comment: Qty.: 0.2531 f(s)/Unit Total : 5.0610 f(s)
 6061-T6 Bar .75" X 1.5"
 Batch: M110167

J.L 09/04/24

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank 2.90 " long

J.L 09/04/24

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA681 Rev: A & Dwg D3571 Rev: A

2-Deburr per dwg D3571

J.L 09/04/29

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 09/04/29

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 09/04/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/04/2009 11:04:20 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 47142

Part Number: D35713

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL

09-04-29

(V20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

13:50

OVEN TEMPERATURE:

320°

FINISH TIME:

14:20

UMP/PL

09/04/30

(X20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-01

(X20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

57245A

09/05/01

(20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/04

Job Completion



MF 09-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47142
Description: Guide		Part Number: D3571-3
Inspection Dwg: D3571	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.699	✓			
2.75	+/-0.030	2.752	✓			
1.38	+/-0.030	1.378	✓			
1.25	+/-0.030	1.249	✓			
0.63	+/-0.010	.628	✓			
0.031 chamfer	+/-0.010	.028	✓			
Ø0.500	+0.006/-0.001	.502	✓			
Ø0.201	+0.005/-0.001	.202	✓			
R0.25	+/-0.030	0.25	✓			
0.260	+0.000/-0.010	.255	✓			
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	388 x 100°	✓			
0.125	+/-0.010	.126	✓			
2.250	+/-0.010	2.241	✓			
0.250	+/-0.010	.257	✓			
0.188	+/-0.010	.189	✓			
0.063 chamfer	+/-0.010	.060	✓			

Measured by: JL
Date: 09/04/28

Audited by: [Signature]
Date: 09/04/28

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

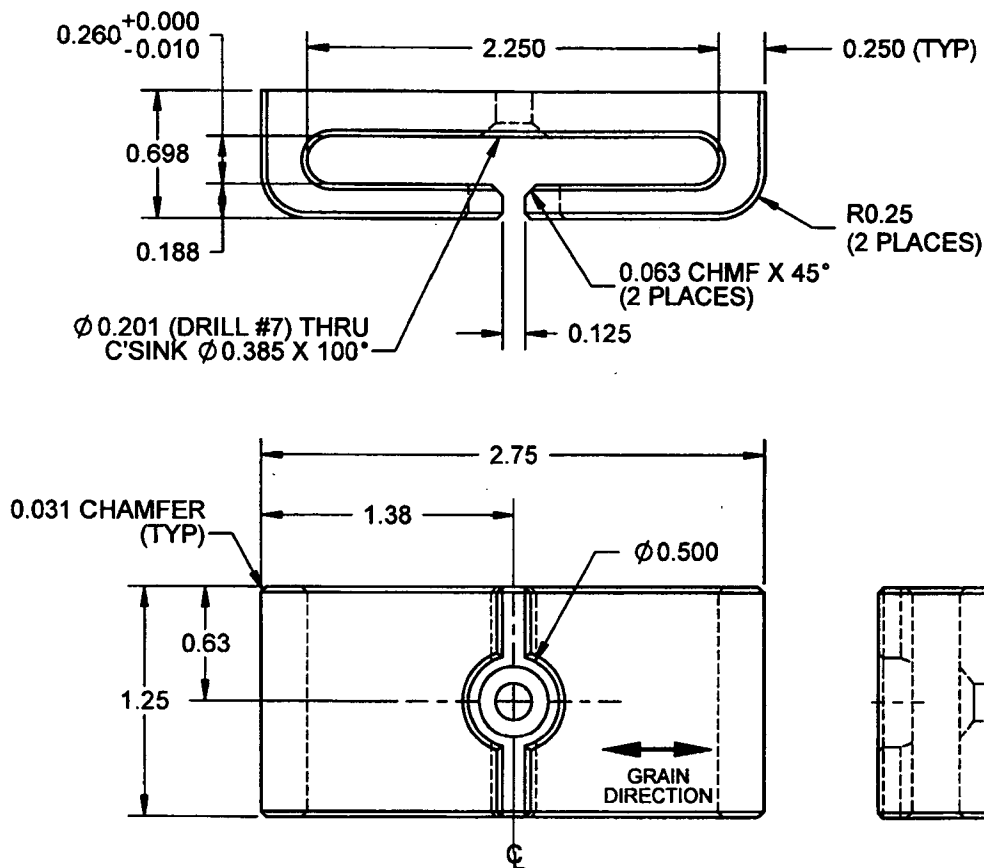


DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 2 OF 2
DATE 07.01.29		TITLE GUIDE	SCALE 1:1

RELEASED

07.01.12

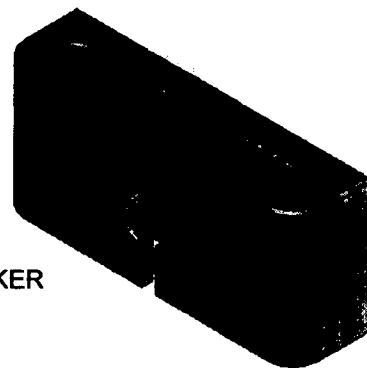
47142



D3571-3 GUIDE

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ



COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries